

Date: Tuesday, 15/07/2008 9:12:04 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	40462		
<b>Estimate Number</b> :	10296		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32203
<b>This Issue</b> :	15/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3220 REV.A1
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40461D	<b>Drawing Revision</b> :	A1
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 08-15-08</u>	<b>Due Date</b> :	21/07/2008
<b>Comment</b> :	Est Rev: A New Issue 05-11-06 JLM	<b>Qty:</b>	10
	Est: B 06.11.15 waterjet EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S050	2024-T3 .050 sheet
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**Comment:** Qty.: 0.6233 sf(s)/Unit Total: 6.2328 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
 (M2024T3S.050  
 Identify for D3220-3  
 Batch: 107711 **IB 8-7-17**

(12)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

A1  
A1**IB 8-7-17****Comment:** FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**IB 8-7-17****Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKSOD 07/17/12

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature and date: 08/07/12  
 (12)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 15/07/2008 9:12:04 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 40462

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-07-17*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *234*

*8/7/17*

*12x*

*50*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/18*

Job Completion



*12/08/18*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



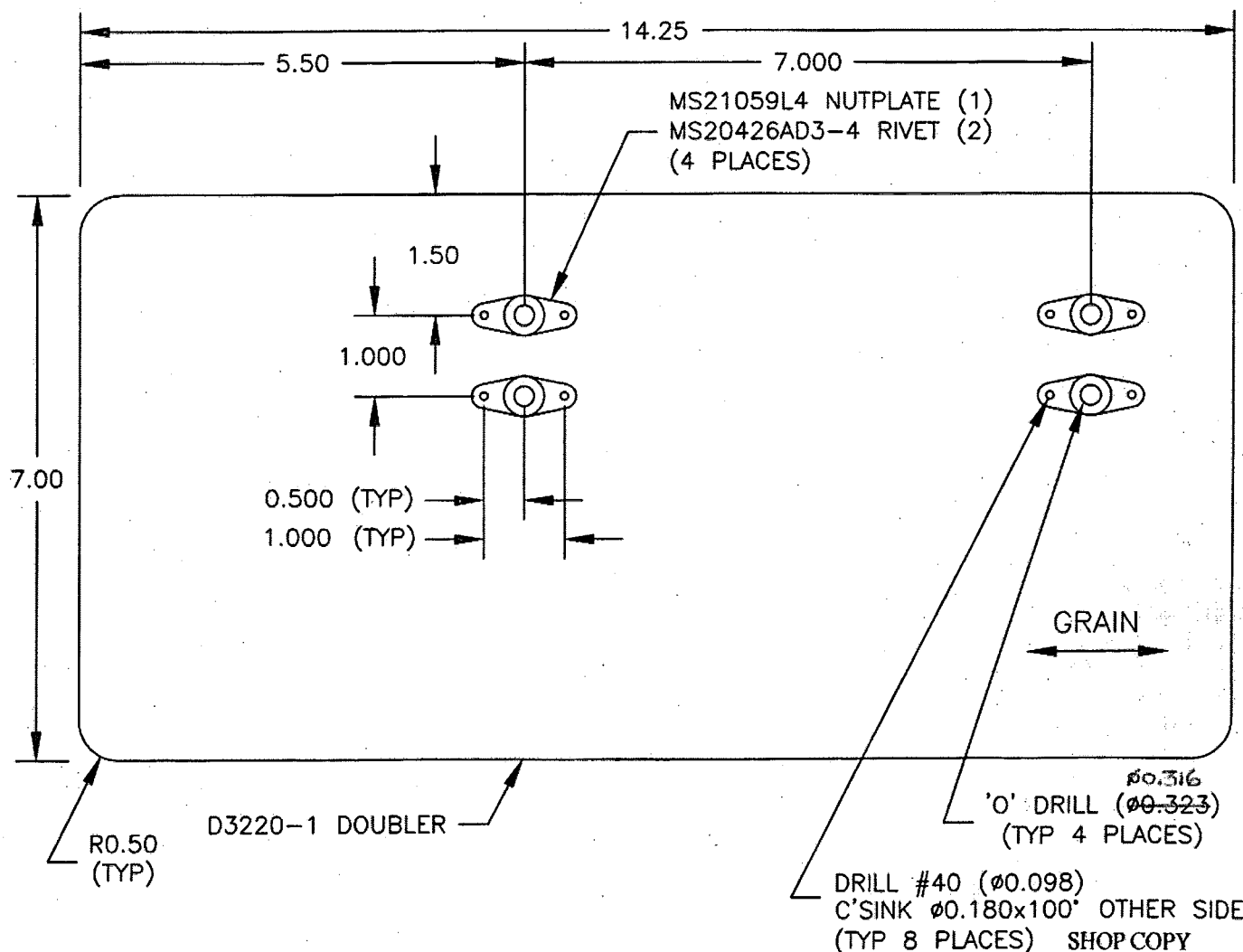






DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3220	REV. A SHEET 1 OF 2
DATE	03.10.16			TITLE DOUBLER	SCALE 1:2
A	03.10.16			NEW ISSUE	
A1	<i>CP</i>	<i>[Signature]</i>	03.11.13	CORRECTED DIM	

RELEASED  
03.11.14 *[Signature]*



**D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RETURN TO  
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WORK ORDER  
NO. *40462*

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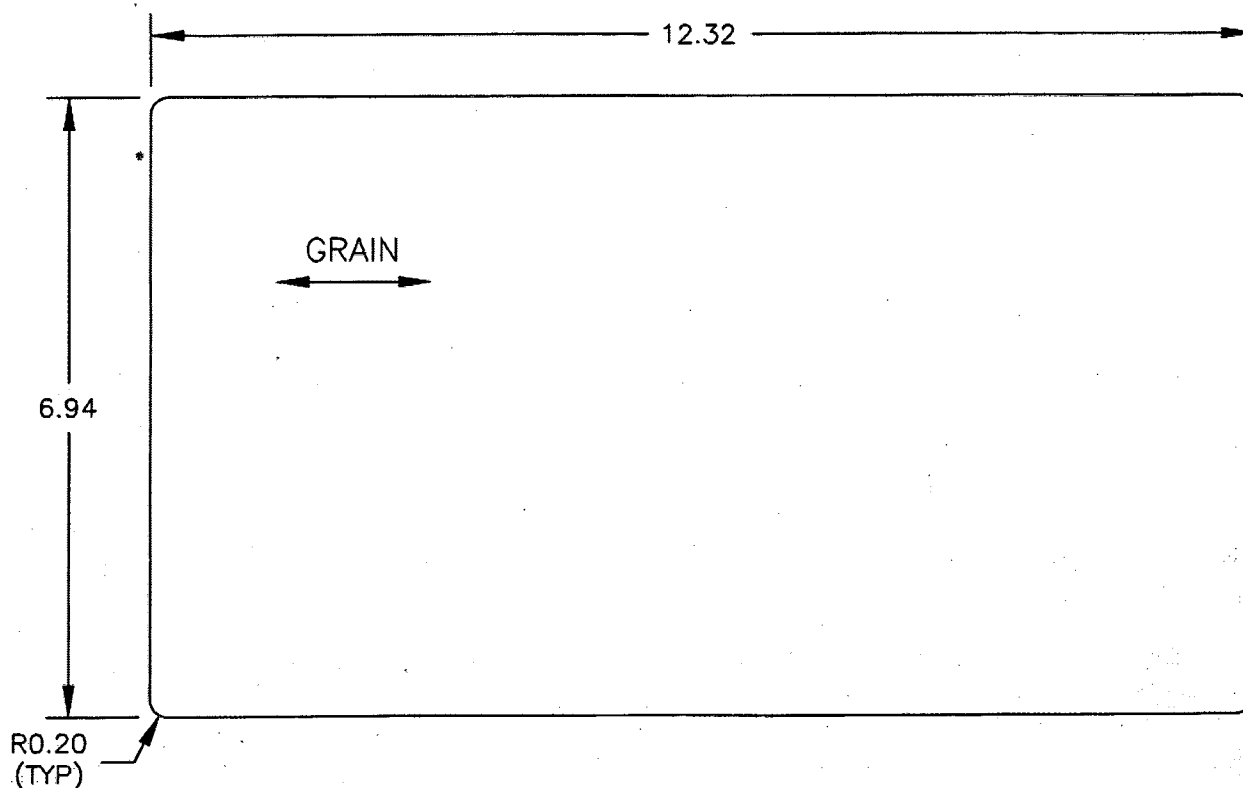
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED  
03.11.14



**D3220-3 DOUBLER**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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